Work	0	rder	ID	92341
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Monday, October 29, 2012 12:09:20 PM

92341

Page 1

D206-817-011 Item ID: Accept *N900040100* Setup Start **Revision ID:** Stop Screw-In Windshield, LH/RH Item Name: 10/29/2012 Start Qty: 1.00 **Start Date: Cust Item ID: Required Date: 10/31/2012** Req'd Qty: 1.00 **Customer:** Reference: REWORK Run Process Plan: Approvals: **Tooling:** Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool # Tool ID Plan Reject Reject Accept Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp Draw Nbr **Revision Nbr** IIN-D206-817 C 150 0.00 *150* Packaging 0.00
PULL FROM STOCK D206-817-011 X 1 B 91719 CH6002 Packaging REMOVE D4541-5 X 1, D4541-6 X 2 & D4542-5 X 2 AND BRING TO ALODINE Chemical Conversion Coat per QSI005 4.1 *160* HandFinish Memo Hand Finishing

												DQA:	Date	2:
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UP	DATE	1	QA Closed:	Date	·····
Work Orde	or.					DISPOSITION			<u> </u>	AGAI	NST DEF	PARTMENT	/PROCESS	
WOIK OIG	-					Rework		Skid-tube Crosstube				Water Jet	Engineering	
Part I	No					Scrap		ı	Machining Small Fab Thermoforming Finishing		Fab	Prod. Eng. Coor. Rec/Store/Packaging		Quality
NCR No.					Work Order Update			Large Fab Composite			,			
Root					Descri	ption of work order update		Initial	Ac	tion		Sign &	,	
Cause		Date	Step	Qty	(or Non-conformance	Cr	nief Eng	Desc	ription		Date	Verification	QC Inspector
Doc/Data	Ш										:			
Equip/Tooling	Ш						13							
Operator					-									
Material									4				*	
Setup														
Other														-
Process														
Supplier			1											
Training								İ					:	
Unapproved									·					
				· · · · · · · · · · · · · · · · · · ·	···	F	AUI	LT CATE	GORY					
Landi	ng G	iear				General	_	21				•		_
	Ш	Bending				Bend		Grain				Ovalized	L	Pressure/Forced
	Ш	Centre No	ot Conce	ntric to	o/s	BOM/Route	L	Hardwa	re			Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorre	ct	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/	'Unclear		Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance			Part Moved		
		Heat Trea	at			Countersink		Mislabe	led			Positioned Wrong		
						Cut Too Short	Misread					Power Loss	/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

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Ripples in Bend

Turning Sequence
Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

92341

Page 2

Monday, October 29, 2012 12:09:20 PM Item ID: D206-817-011 Accept *N900040100* Setup Start **Revision ID:** Screw-In Windshield, LH/RH Item Name: **Start Date:** 10/29/2012 | Start Qty: 1.00 **Cust Item ID: Required Date:** 10/31/2012 Req'd Qty: 1.00 **Customer: REWORK** Reference: Start Run Date: 'd' Approvals: **Process Plan:** Tooling: Date: Stop SPC (Y/N): OC: Date: Date: Sequence ID/ Operation Set Up/ Reject Tool ID Tool # Plan Reject Insp. Accept **Work Center ID Description** Run Hours Qty Code Qty Number Stamp 170 QC7-Inspect Chemical Conversion Coat 0.00 *170* QC 0.00 Memo Quality Control Identify as per dwg & Stock Location: 0.00 Packaging 0.00 Memo Packaging QC4-100% Inspect kits for completeness QC Memo Quality Control

											DQA:	Date:		
NCR:	Yes	/ No				WORK ORDER NON-C	OI	NFORM	MANCE / UPD	ATE	QA Closed:	Date:		
Work Orde		<u> </u>				DISPOSITION		1		AGAINST DE	<i>*</i>	· · · · · · · · · · · · · · · · · · ·		
Part No. NCR No.						Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstube Small Fab Thermoforming Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root					Descri	l ption of work order update		nitial	Actio	on	Sign &	0	Ÿ	
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descrip	otion	Date	Verification	QC inspector	
Doc/Data								*						
Equip/Tooling							- :			3				
Operator					_				100		1			
Material														
Setup						,								
Other													1	
Process									4. **					
Supplier						77		-						
Training		• •		·	*			i.	- 2					
Unapproved			į					6 - * * ·		-1-				
						F	AUI	T CATE	GORY					
Landi	ng (Sear	_			General		_			_		_	
		Bending				Bend		Grain			Ovalized		Pressure/Forced	
		Centre Not Concentric to O/S BOM/Route				BOM/Route		Hardwa	re	,	Over/Under	r tolerance	Temperature/Cure	
		Cracks Broken/Damaged			Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ect	Weld		
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/Ur	nclear	Part Lost/M	lissing	Wrong Stock Pulled	
		Cuffs	•			Contamination		Mainte	enance		Part Moved		- 1	
		Heat Trea	it			Countersink		Mislabe	led		Positioned '	Wrong	- 7	
		Inspection Strip in Tube Cut Too Short				Cut Too Short		Misread	t		Power Loss/Surge Other			

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Work Order ID 92341

Quality Control

92341

Page 3

Monday, October 29, 2012 12:09:20 PM D206-817-011 Item ID: Accept *N900040100* Setup Start **Revision ID:** Screw-In Windshield, LH/RH Item Name: **Start Date:** 10/29/2012 Start Qty: 1.00 **Cust Item ID: Required Date:** 10/31/2012 Reg'd Oty: 1.00 **Customer: REWORK** Reference: Approvals: **Process Plan:** Date: **Tooling:** Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Accept Reject Reject Plan Insp. Work Center ID Description **Run Hours** Qty Code Qty Number Stamp QC21- Final Inspection - Work Order Release 0.00 QC 0.00 Memo

MLJ 12-11-01

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-	CONFOR	MANCE / UPI	DATE	QA Closed:	Date:	
·····					T				<i>(</i>		<u>.</u>
Work Orde	er:				DISPOSITION	1	W.	AGAINST DE	PARTMENT	PROCESS	
					Rework	7 i	Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.				Scrap	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
		,			Use-as-is Thermoforming Finishing				re/Packaging	Other	
NCR N	lo.				Work Order Update	1	Large Fab	Composite	1	Supplier	
Root				Descri	iption of work order update	Initial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data			-								4
quip/Tooling											
Operator				_							
Material			1			*					200
Setup											
Other							- F				
Process						9.5					34.0
Supplier										8	
Training				<u> </u> 							
Unapproved			<u> </u>	<u> </u>		<u> </u>	<u> </u>		1	<u> </u>	
						AULT CAT	EGORY	2			
Landir 1	ng Gear			_	General		11.5		٠		٦. ،
	Bending				Bend	Grain			Ovalized	_	Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route	Hardw		-	Over/Under	-	Temperature/Cure
	Cracks			-	Broken/Damaged		tion Incomplete	–	Part Incorre		Weld
	Crushed/	Crimped		-	Burrs	·	ctions Incomplete/U	Jnclear	Part Lost/M		Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination	\vdash	tenance	<u> </u>	Part Moved		
	Heat Trea		T . 1	-	Countersink	Mislat			Positioned \		Joshan
	Inspectio	•	Tube	-	Cut Too Short	Misrea		L.	Power Loss,	Surge	Other
	Ripples in		F		Drill Holes	Offset				W	
1.0	Torque W	vaves in l	Extrusio	n	Drawing	Out of	Calibration				

Out of Sequence

Outside Dimensions

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Turning Sequence
Wave/Twist in Tube

Finish

Folio

Picklist Print

Monday, October 29, 2012 12:09:19 PM

Page 1

Work Order ID:

92341

Parent Item:

D206-817-011

Parent Item Name:

Screw-In Windshield, LH/RH

Start Date: 10/29/2012

Required Date: 10/31/2012

Start Oty: 1.00

Required Qty: 1.00

IPP REV:A 12.02.14 NEW ISSUE DD VERF:

REV.C DD VERF:EC

IPP REV:B 12.05.09 AS PER IIN

IPP REV:C 12.06.12 ECN 12-602 DD VERF:EC

	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-817-011	-	Manufactured	No			200	Each	0.0000		1			

Screw-In Windshield, LH/RH

											DQA:	Date	2:
NCR:	Yes /	No			WORK ORDER NON-C	COI	NFORM	MANCE / UPE)ATE		QA Closed:	Date	a.
Work Orde					DISPOSITION				AGAIN!		PARTMENT		
Part No. NCR No.					Rework Scrap Use-as-is Work Order Update	Therm	Skid-tube Crosstube Small Fab Thermoforming Finishing Composite				Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other	
Root				Descri	ption of work order update	6.1	Initial	Acti	ion		Sign &		
Cause	Da	te Step	Qty		or Non-conformance	Ch	nief Eng	Descri	iption		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
		•,			F.	AUL	LT CATE	GORY	-				
Landi	Crac Crus Cuff Hear	re Not Conc ks hed/Crimpe	d.	o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		- d	ion Incomplete ions Incomplete/L enance eled	Jnclear		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
1	Ring	les in Rend			Drill Holes	1	Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio November-07-12 7:41:29 AM

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt Lot Code	Type Code	Comments
D206-817-011 Screw-In Windshield, LH/RH	Main Warehouse FG	92340	11/05/12	20.0000	QC21	CHG002	
ALI/KII	Main Warehouse FG119	92341	11/05/12	1.0000	QC21	CHG002	

NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE										
				QA Closed:							
Work Order:	DISPOSITION		AGAINST DE	PARTMENT/PF							
Work Graci.	Rework	Skid-tube	Crosstube								
Part No.	Scrap	Machining	Small Fab	Prod. l							
	Use-as-is	Thermoforming	Finishing	Rec/Store/							

Work Order Update

Description of work order update

or Non-conformance

General

Bend

Burrs

BOM/Route

Broken/Damaged

Qty

Step

Centre Not Concentric to O/S

	DQA:	Da	te:	
ATE	•			1
	QA Closed:	Da	te:	
AGAINST DE	PARTMENT	PROCESS		
Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. e/Packaging Supplier		neering Quality Other
on otion	Sign & Date	Verificatio	n 00	C Inspector
	Juic	Vermedalo		
nclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V	ct issing Vrong	Tempo Weld	ure/Forced erature/Cure g Stock Pulled

DQA:

		Cuffs	Contamination	Maintenance	Ш	Part Moved	
		Heat Treat	Countersink	Mislabeled		Positioned Wrong	
		Inspection Strip in Tube	Cut Too Short	Misread		Power Loss/Surge	Other
		Ripples in Bend	Drill Holes	Offset			
		Torque Waves in Extrusion	Drawing	Out of Calibration			
		Turning Sequence	Finish	Out of Sequence			
		Wave/Twist in Tube	Folio	Outside Dimensions			
·/FORMS/Ouz	litv	Assurance\approved OA/NCRWO Rev G					

FAULT CATEGORY

Grain

Hardware

Inspection Incomplete

Instructions Incomplete/Unclear

Large Fab

Initial

Chief Eng

Action

Description

NCR No.

Landing Gear

Bending

Cracks

Crushed/Crimped.

Date

Root

Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved